

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026313**Date Inspected:** 19-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 11W 12W E2 R1 (Interior)
2. 11E PP111 E3 Lifting Lug Holes (Exterior)
3. 9W PP76 W4 Lifting Lug Holes (Exterior)
4. 10W 11W C1/C2/D1/D2 (Interior)

1. 11W 12W E2 R1 (Interior)

The QA inspector noted the dimensions of the excavation at A5 y+45125 as 80mm's in length and 6mm's deep. The QA inspector observed the QC inspector identified as Jesse Cayabyab perform Magnetic Particle inspection on the sites and found no indications. The QA inspector observed ABF welder Wai Kit Lai ID#2953 perform Shielded Metal Arc Welding (SMAW) in the 1G flat position with the QC inspector being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1001-Repair. The QA inspector noted that the work appeared to be in general conformance with the contract documents.

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2. 11E PP111 E3 Lifting Lug Holes (Exterior)

The QA inspector observed ABF welder Fred Kaddu ID# 2188 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #4 located at 11E PP111 E3. The QA inspector verified the fit up of the joint and found it to be satisfactory. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU.

The parameters were recorded as (Amperes=135).

The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work appeared to be in general conformance with the contract documents.

3. 9W PP76 W4 Lifting Lug Holes (Exterior)

The QA Inspector performed a Magnetic Particle Test (MT) on Lifting Lug Holes #1-4 at 9W PP76 W3 on the exterior of the OBG. The QA Inspector utilized the MT procedure SE-MT-D1.5-CT-100 Rev. 4 to test 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents.

4. 10W 11W C1/C2/D1/D2 (Interior)

The QA Inspector performed a Magnetic Particle Test (MT) on side plate C1/C2 and bottom plate D1/D2 on the interior of the OBG. The QA Inspector utilized the MT procedure SE-MT-D1.5-CT-100 Rev. 4 to test 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents.

Summary of Conversations:

At the beginning the shift the QA inspector met with QC inspector William Sherwood and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer